

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007911**Date Inspected:** 17-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zou Liu Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower struts and OBG floorbeam**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG sub assembly bay 2**

This QA observed ZPMC personnel fitting a temporary stiffener to OBG floorbeam identified as FB028-009. This QA noted that this floorbeam is an FL3 and the stiffener was being tacked welded to the SPCM portion of this floorbeam. This QA reviewed the approved OBG assembly procedure and it appeared as though this temporary stiffener was indicated on the procedure drawing. No further action was taken by this QA concerning this issue.

**OBG sub assembly bay 6**

This QA observed ZPMC qualified welding personnel identified as 068091 perform SMAW welding on weld joint identified as WD1-305-65M-3-2B. ZPMC QC CWI identified as Mr. Zou Liu Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

This QA observed ZPMC qualified welding personnel identified as 037932 perform SMAW welding on weld joint identified as WD1-305-65M-3-8A. ZPMC QC CWI identified as Mr. Zou Liu Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general

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compliance with WPS-B-T-3212-Tc-U5b-1.

This QA observed ZPMC qualified welding personnel identified as 066456 perform SMAW welding on weld joint identified as WD1-A305-77M-3-8A. ZPMC QC CWI identified as Mr. Zou Liu Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

This QA observed ZPMC qualified welding personnel identified as 037780 perform SMAW welding on weld joint identified as WD1-A305-77M-3-2B. ZPMC QC CWI identified as Mr. Zou Liu Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

OBG sub assembly bay 8

This QA observed ZPMC personnel drilling holes in the flanges of several of the tower struts in this bay. No other work was observed in this bay during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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